

Environmental Product Declaration (EPD) of acoustic insulation product

in accordance with ISO 14025:2006 and with EN15804:2012+A2:2019



Programme: The International EPD® System, www.environdec.com

Programme operator: EPD International AB

Registration number: **S-P-01948**

Date of publication: 2020/03/13

Date of revision: 2021/06/04

Date of validity: 2025/03/10

CPC 3622 - Unvulcanized compounded rubber, in primary forms or in plates, sheets or strip; unvulcanised rubber in forms other than primary forms or plates, sheets or strip (except "camel-back" strips for retreading rubber tyres); articles of unvulcanised rubber; thread, cord, plates, sheets, strip, rods and profile shapes, of vulcanized rubber other than hard rubber

PCR 2019:14: "Construction products" version 1.0 valid until 20/12/2024

Geographical area: Europe

An EPD should provide current information and may be updated if conditions change. The stated validity is therefore subject to the continued registration and publication at www.environdec.com

COMPANY INFORMATION

THE COMPANY

K-FLEX® is an Italian manufacturing company specialised in the production of thermal and acoustic flexible elastomeric insulation materials. K-FLEX® has production facilities and subsidiary networks around the globe in order to supply their products to a world-wide customer base. Its diversified products range provides solutions for various market sectors, including building, transportation, petrochemical and renewable energy. K-FLEX® is a worldwide market leader thanks to its focus on technological innovation and the quality of its products that play an essential role in energy consumption control and reduction of the greenhouse gas emission.

K-FLEX® is an example of a successful Italian company that has established itself worldwide. The company is present in 63 countries, with production facilities in all continents and more than 2500 employees. In addition, the company has commercial distribution branches, located all over the world, for the efficient and effective global distribution process of its products. The original manufacturing plant, located in Roncello (north of Milan), was founded in 1989 and today it is the largest in the world for the production of elastomeric insulation.

K-FLEX HISTORY

K-FLEX® was founded in 1989 in Roncello, located north of Milan, Italy, with the first production plant of elastomeric materials for thermal insulation. K-FLEX® quickly developed its presence in the market and grew rapidly. In 1993, K-FLEX® had already established a significant market share in Italy. It subsequently expanded into other European markets such as France and Spain, opening in Barcelona in 1995 and in Madrid in 1998. Almost ten years after its foundation, K-FLEX® began its expansion outside Europe starting up K-FLEX® China. Based in Guangzhou was the first of two manufacturing plants with a second plant built in Suzhou, which opened in 2009. The Company built further production facilities in the US, in Russia in 2005, in Malaysia, Poland, India and Dubai. In order to expand its commercial footprint, the Company opened distribution branches and various other distribution / sales companies in Germany (2000), Scandinavia (2005), United Kingdom (2006), Romania (2008), Japan (2008), Ukraine (2009), South Korea (2009). In the 2008 another strategic activity was the 100% share acquisition of BevEx Ltd. BevEx offers an important diversification opportunity for K-FLEX® through its presence in the Food & Beverage sector. At the end of 2009, K-FLEX® opened its headquarter in Roncello, housing a 50,000 sq. meter production facility. In the last few years K-FLEX® has been expanding the production facilities in Russia, Poland, India and USA in order to better answer to the local market request. In June 2014, the company changed its legal form from limited liability company (S.r.l.) to joint stock company (S.p.A.). In 2017, the plant in the USA was extended towards the biggest and most modern plant worldwide. Moreover, the Polish plant was extended in 2017 and represents the biggest and most modern plant in Europe. In 2018, a new production site in Egypt was opened. In 2018, the new K-FLEX® logistics centre “K-FLEX®Logistikzentrum Leipzig-Halle” in Germany was opened. It is now the biggest distribution centre for elastomeric foams in

whole Europe. In 2019, a new production site in Vietnam has been opened in support of the Asian region market request. In the same year K-FLEX® implemented his Polish factory with a new polyethylene production plant. In 2020, a new production site in Mexico was opened to support the growing of South American market

This declaration refers to products made in the Polish plant in Uniejów.


PRODUCT INFORMATION

The insulation product is a material that, thanks to particular characteristics, prevents the transmission or diffusion of thermal, acoustic, electrical or other energy, depending on the application for which it is intended. The present LCA study refers to an acoustic insulation product made by K-Flex, which is described below:

- K-FLEX® K-FONIK is a viscoelastic acoustic insulation product made with partially reticulated polymers. Its special sound insulation characteristics make this an excellent product for traditional applications in the construction sector, eg. acoustic insulation of brick walls and plasterboards and for O. E. M. application.

The following table show the technical characteristics of the product.

Characteristics of acoustic insulation product K-FLEX K-FONIK

Property	Value	
Material type	High density elastomeric material	
Weight	From 4 to 8 Kg/m ²	
Fire classification	EN 13501 - Bs3d0 ¹⁾ , IMO A653 (CE MARINE) ²⁾ , FMVSS 302	
Temperature range	-40°C +70°C	
Dimensions	1000 x 2000 and 1000 x 1200 mm Rolls 25 or 50 m	
Surface	Smooth	
Density	2.100 kg/m ³ (± 10%)	
Colour	Black	
¹⁾ only for K-FONIK GK on request		
²⁾ only for K-FONIK GV		

LCA INFORMATION

DECLARED UNIT

This life cycle analysis, defined as "from-cradle-to-gate with modules C and module D", takes into consideration the production phases of raw materials, their transportation to the production site, the manufacture and the end of life of the product, excluding the distribution and use phase. As regards the flows of matter and energy, declared unit is defined as:

1 m³ of acoustic insulation product, including packaging

The density considered for the product derives from an average of the production of the reference year (2020) and it is shown in the following table.

Density of acoustic insulation product

Product	Density
K-FLEX K-FONIK	2.100 Kg/m ³

SYSTEM BOUNDARIES

The system boundaries determine the process units to be included in the LCA study and which type of data "input" and / or "output" to the system can be omitted. In accordance with the PCR 2019:14 version 1.0 document and EN 15804, the life cycle of the acoustic insulation products made by K-Flex includes the extraction of raw materials and production cycle, transport and manufacturing, divided in the Upstream (A1), Core (A2 and A3) and End of Life (C) and Benefits and loads beyond the system boundary (D) phases. The construction process stage and the use stage (phases from A4 to B7 of PCR 2019:14) are not taken into account in this life cycle analysis.

	LIFE CYCLE INFORMATION															Supplementary information	
	Product stage			Construction process stage		Use stage						End of life stage				Benefits and loads beyond the system boundary	
	A1 - A3			A4 - A5		B1 - B5					B6 - B7		C1 - C4				D
	Raw material supply	Transport	Manufacturing	Transport	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse, recovery, recycling potential
	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Module declared	X	X	X	ND	ND	ND	ND	ND	ND	ND	ND	ND	X	X	X	X	X
Geography	PL WORLD	EU WORLD	PL										PL	PL	PL	PL	PL
Specific data	>90%																Not relevant
Variation - products	Not relevant																Not relevant
Variation - sites	Not relevant																Not relevant

ND: Module not declared

The **Upstream** (A1) phase includes raw material extraction and processing, and in particular:

- ✓ Extraction and processing of raw materials (e.g. mining processes);
- ✓ Generation of electricity, steam and heat from primary resources, also including their extraction, refining and transport;

The **Core** (A2-A3) phase includes following processes:

- ✓ Transportation up to the factory gate and internal transport (A2);
- ✓ Production of ancillary materials or pre-products (A3);
- ✓ Manufacturing of products and co-products (A3);
- ✓ Manufacturing of packaging (A3);
- ✓ Processing up to the end-of-waste state or disposal of final residues (A3).

The **End of life** (A2-A3) stage includes following processes:

- ✓ De-construction, demolition (C1);
- ✓ Transport to waste processing (C2);
- ✓ Waste processing for reuse, recovery and/or recycling (C3)
- ✓ Disposal (C4).

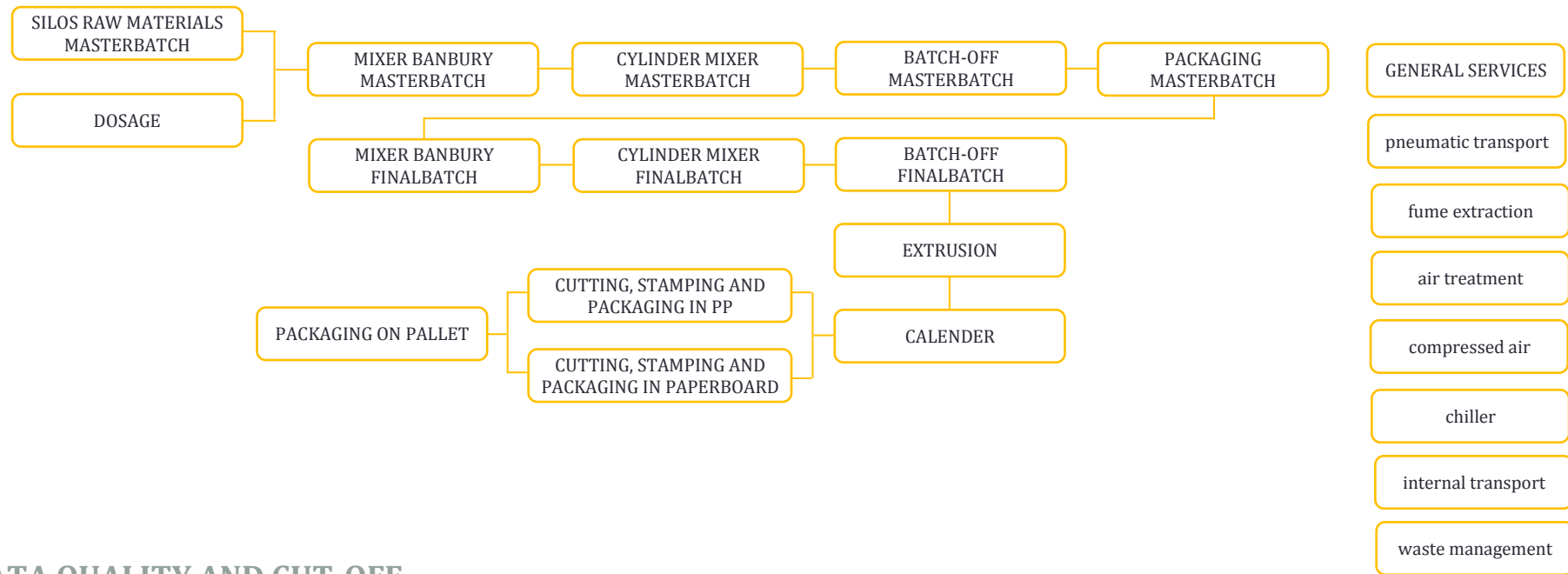
Module D includes reuse, recovery and/or recycling potentials, expressed as net impacts and benefits.

In the end of life stage, the K-Flex acoustic insulation product is sent exclusively to landfill. As there are no possibilities to separate the insulation product from the brick walls, plasterboards etc., phase C1 (de-construction and demolition) is irrelevant; moreover, the product is only disposed, so phase C3 (waste treatment for reuse, recovery and / or recycling) is equal to zero. The result of phase D is also equal to zero, because there are no benefits deriving from the end of life (recycling, recovery and / or reuse).

PRODUCTION PROCESS

Weighting out raw materials from the warehouse according to the recipe for the actual production. Mixing weighted out all components in a mixer, and after in a roll mill to complete the mixing of the “Masterbatch”. After the pick up of small samples, prepared for quality controls, the batch is transported to the calander area, where the material is laminated according to the thickness and size needed. The last step before packaging in small rolls is cutting to required lengths. Small samples of finished products are constantly picked-up during the whole production.

SYSTEM DIAGRAM



DATA QUALITY AND CUT-OFF

Inventory analysis was conducted using specific data from K-Flex., relating to the year 2020 and to the production site of Uniejów. The data refer to the consumption of raw materials and electricity, the production of the acoustic insulation products and the waste connected to it.

Selected generic data from international databases were used (Ecoinvent 3.6) regarding the production processes of raw materials and auxiliary materials used for the production, generation and distribution of electricity, means of transport and waste treatment processes related to the production that takes place in the plant. In addition, data on ground transportation distances were calculated using the Google Maps online calculator and those by sea using the Searates online tool.

The emissions of the upstream electricity used in manufacturing process and modelled as Poland electricity residual mix are 995 g CO₂eq/kWh (AIB 2019).

In accordance with the cut-off rule, packaging of raw material and ancillary were excluded from the assessment.

CONTENT INFORMATION

Content declaration of acoustic insulation products

Product	Product components	Weight, kg	%	Post-consumer material, weight-%	Renewable material, weight-%
K-FLEX K-FONIK	Polymers	327,6	15,6%	0%	0%
	fillers	1.635,9	77,9%	0%	0%
	Plasticizer	77,7	3,7%	0%	0%
	Others	58,8	2,8%	0%	0%
	TOTAL	2.100	100%	0%	0%
	Packaging components	Weight, kg		Weight-% (versus the product)	
	Paperboard	226,0		10,8%	
	Pallet	78,5		3,7%	
	TOTAL	304,5		14,5%	

K-FLEX products does not contain substances that are listed in the “Candidate List of Substances of Very High Concern for authorisation” in concentrations greater than 0,1%.

ENVIRONMENTAL INFORMATION

In order to reach the results reported below, one of the most widespread application software was used for the evaluation of the product life cycle, namely SimPro 9. Furthermore, the most recent databases on the production of materials, the production cycles in the metallurgical and chemical sector, transports and energy systems were used (Ecoinvent 3.6).

ASSESSMENT METHOD

The assessment methods adopted for the LCA study reported in this EPD are described in EN 15804 annex C “Impact categories and related indicators, methodologies and characterization factors”.

Results of environmental impacts of 1 m³ of K-FLEX K-FONIK

Potential environmental impacts	Unit	A1	A2	A3	Total A1-A3	C1	C2	C3	C4	D
GWP-fossil	kg CO ₂ eq	4,43E+03	2,42E+02	2,24E+02	4,89E+03	0E+00	1,44E+01	0E+00	2,00E+02	0E+00
GWP-biogenic	kg CO ₂ eq	2,69E+00	1,24E-02	5,69E+00	8,39E+00	0E+00	7,40E-04	0E+00	6,96E-03	0E+00
GWP-luluc	kg CO ₂ eq	8,82E+00	1,92E-03	1,32E+00	1,01E+01	0E+00	1,15E-04	0E+00	1,30E-03	0E+00
GWP total	kg CO ₂ eq	4,44E+03	2,42E+02	2,31E+02	4,91E+03	0E+00	1,44E+01	0E+00	2,00E+02	0E+00
ODP	mg CFC-11 eq	1,31E-04	5,64E-05	3,21E-05	2,20E-04	0E+00	3,36E-06	0E+00	2,04E-06	0E+00
AP	moli H ⁺ eq	2,66E+01	8,38E-01	1,07E+00	2,85E+01	0E+00	5,02E-02	0E+00	1,02E-01	0E+00
EP-freshwater	kg P eq	3,61E+00	1,22E-03	1,00E-01	3,72E+00	0E+00	7,28E-05	0E+00	4,89E-04	0E+00
EP-marine	kg N eq	3,87E+00	2,68E-01	3,84E-01	4,53E+00	0E+00	1,61E-02	0E+00	4,47E+00	0E+00
EP-terrestrial	moli N eq	3,40E+01	2,95E+00	3,38E+00	4,03E+01	0E+00	1,77E-01	0E+00	4,70E-01	0E+00
POCP	kg NMVOC eq	1,12E+01	8,06E-01	9,00E-01	1,29E+01	0E+00	4,84E-02	0E+00	1,79E-01	0E+00
ADP-min&met*	g Sb eq	9,33E-03	1,43E-05	1,18E-03	1,05E-02	0E+00	8,56E-07	0E+00	4,49E-06	0E+00
ADP-fossil*	MJ	5,65E+04	3,43E+03	2,96E+03	6,29E+04	0E+00	2,05E+02	0E+00	1,24E+02	0E+00
WDP*	m ³ eq	1,47E+03	-7,64E-01	7,87E+01	1,55E+03	0E+00	-4,56E-02	0E+00	2,01E-01	0E+00

* The results of this environmental impact indicator shall be used with care as the uncertainties of these results are high or as there is limited experience with the indicator.

Potential environmental impacts - additional indicator	Unit	A1	A2	A3	Total A1-A3	C1	C2	C3	C4	D
GWP-GHG**	kg CO ₂ eq	4,44E+03	2,42E+02	2,26E+02	4,90E+03	0E+00	1,44E+01	0E+00	2,00E+02	0E+00

** The indicator includes all greenhouse gases included in GWP-total but excludes biogenic carbon dioxide uptake and emissions and biogenic carbon stored in the product. This indicator is thus equal to the GWP indicator originally defined in EN 15804:2012+A1:2013.

GWP-fossil = Global Warming Potential fossil fuels; GWP-biogenic = Global Warming Potential biogenic; GWP-luluc = Global Warming Potential land use and land use change; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential, Accumulated Exceedance; EP-freshwater = Eutrophication potential, fraction of nutrients reaching freshwater end compartment; EP-marine = Eutrophication potential, fraction of nutrients reaching marine end compartment; EP-terrestrial = Eutrophication potential, Accumulated Exceedance; POCP = Formation potential of tropospheric ozone; ADP-minerals&metals = Abiotic depletion potential for non-fossil resources; ADP-fossil = Abiotic depletion for fossil resources potential; WDP = Water (user) deprivation potential, deprivation-weighted water consumption

Results of use of resources, waste production, output flows of 1 m³ of K-FLEX K-FONIK

Use of resources	Unit	A1	A2	A3	Total A1-A3	C1	C2	C3	C4	D
PERE	MJ	2,05E+03	4,82E+00	2,18E+03	4,23E+03	0E+00	2,87E-01	0E+00	1,51E+01	0E+00
PERM	MJ	9,01E+02	3,50E+00	1,84E+03	2,75E+03	0E+00	2,09E-01	0E+00	2,25E-01	0E+00
PERT	MJ	2,95E+03	8,31E+00	4,03E+03	6,98E+03	0E+00	4,96E-01	0E+00	1,53E+01	0E+00
PENRE	MJ	4,87E+04	3,44E+03	3,34E+03	5,55E+04	0E+00	2,05E+02	0E+00	1,42E+02	0E+00
PENRM	MJ	1,24E+04	9,92E-03	2,36E+01	1,24E+04	0E+00	5,92E-04	0E+00	1,02E-01	0E+00
PENRT	MJ	6,11E+04	3,44E+03	3,36E+03	6,79E+04	0E+00	2,05E+02	0E+00	1,42E+02	0E+00
SM	kg	0E+00	0E+00	2,26E+02	2,26E+02	0E+00	0E+00	0E+00	0E+00	0E+00
RSF	MJ	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00
NRSF	MJ	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00
FW	m ³	1,21E+02	5,16E-03	2,94E+00	1,23E+02	0E+00	3,08E-04	0E+00	4,87E-02	0E+00

Waste production	Unit	A1	A2	A3	Total A1-A3	C1	C2	C3	C4	D
HW	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0E+00	0,00E+00	0E+00	0,00E+00	0E+00
NHW	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0E+00	0,00E+00	0E+00	0,00E+00	0E+00
RW	kg	9,21E-02	3,17E-02	2,07E-02	1,44E-01	0E+00	1,49E-03	0E+00	1,12E-03	0E+00

Output flows	Unit	A1	A2	A3	Total A1-A3	C1	C2	C3	C4	D
REUSE	kg	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00
RECYCLE	kg	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00
EN-REC	kg	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00
EE-EL	MJ	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00
EE-ET	MJ	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00	0E+00

PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy re-sources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water; HP = Hazardous waste disposed; NHW = Non-hazardous waste disposed; RW = Radioactive waste disposed; REUSE = Components for reuse; RECYCLE = Materials for recycling; EN-REC = Materials for energy recovery; EE-EL = Exported energy, electricity; EE,TH = Exported energy, thermal

Information on biogenic content of 1 m³ of K-FLEX K-FONIK

Biogenic carbon content	Unit	K-FLEX FONIK
Biogenic carbon content in product	kg	0
Biogenic carbon content in packaging	kg	1,35E+02

DIFFERENCES VERSUS PREVIUOS VERSION

As the Ecoinvent database was updated, from version 3.5 to version 3.6, the company has decided to update the published EPD. All the environmental performances show lower values even if the differences are within the range of 1% - 2%, with the exception of the ODP indicator that increases by 8-9% (depending on the product), but this increase is due to the update of the database and not to changes in the production process of K-FLEX.

ADDITIONAL ENVIRONMENTAL INFORMATION

UNI EN ISO 9001:2015 and ISO 14001 certified, the company offers a wide range of products that ensure quality, reliability and compliance with market standards. K-FLEX® products also play a very important role in conserving the environment by improving the relationship between energy consumption and pollutant emissions, controlling energy consumption and reducing the release of greenhouse gas in the atmosphere.

REFERENCES

1. ISO 14040:2006 Environmental management – Life cycle assessment - Principles and Framework
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5. EN 15804:2012+A2:2019 Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products
6. Rapporto LCA prodotti isolanti, revisione 00 – 2021.05.24
7. Association of Issuing Bodies, European Residual Mixes 2019

CONTACTS

K-FLEX
Ambiente Italia S.r.l.

K-FLEX
International EPD® system

Gianluca Consentino, gconsentino@kflex.com
Simona Canzanelli, simona.canzanelli@ambienteitalia.it

<http://www.kflex.com>
<http://www.environdec.com>

Programme information

Programme:	<p>The International EPD® System</p> <p>EPD International AB Box 210 60 SE-100 31 Stockholm Sweden</p> <p>www.environdec.com info@environdec.com</p>
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The EPD owner has the sole ownership, liability, and responsibility for the EPD.

EPDs within the same product category but from different programmes may not be comparable. EPDs of construction products may not be comparable if they not comply with 15804. For further information about comparability, see EN 15804 and ISO 14025.

CEN standard EN 15804 serves as the core Product Category Rules (PCR)
Product category rules (PCR): 2019:14 Construction products, version 1.0
<p>PCR review was conducted by: <i>The Technical Committee of the International EPD® System. See www.environdec.com/TC for a list of members. Review chair: Claudia A Pena, University of Concepcion, -cile. The review panel may be contacted via info@environdec.com.</i></p>
<p>Independent third-party verification of the declaration and data, according to ISO 14025:2006:</p> <p><input type="checkbox"/> EPD process certification <input checked="" type="checkbox"/> EPD verification</p>
<p>Third party verifier: <i>Guido Croce</i> Approved by: The International EPD® System Technical Committee, supported by the Secretariat</p>
<p>Procedure for follow-up of data during EPD validity involves third party verifier: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No</p>